

Date: Friday, 9/14/2007 2:00:51 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG	
Job Number	: 34671B				
Estimate Number	: 10841				
P.O. Number	: N/A		Part Number	: D22493	
This Issue	: 9/14/2007	S.O. No. : <u>WA</u>	Drawing Number	: D2249 REV. E	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: E	
Previous Run	: 31609B		Material	: N/A	
Written By			Due Date	: 10/20/2007	
Checked & Approved By			Qty:		
Comment	: Est: D 05.02.04 Added Step 9 KJ/RF Est Rev:E Now On Waterjet 07-03-08 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 0.1470 sf(s)/Unit Total : 1.4700 sf(s) 304/316 .063 Sheet Batch: <u>M101873</u> <u>B</u> <u>07-09-19</u> <u>M105130</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2249 Dwg Rev: <u>E</u> <u>B</u> <u>07-09-19</u> Prog Rev: <u>E</u>		
2-Deburr if necessary <u>B07-09-19</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B07-09-19</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>E</u> <u>0709180</u> <u>438</u> <u>counters</u>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per Dwg D2249 <u>SB</u> <u>07/09/18</u> <u>38</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 01/09/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 34671B

Part Number: D22493

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



current
en 09/27 38

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PAT

09/28

(38)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(39)

Comment: FINAL INSPECTION/W/O RELEASE

09/28

Job Completion



U 09/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

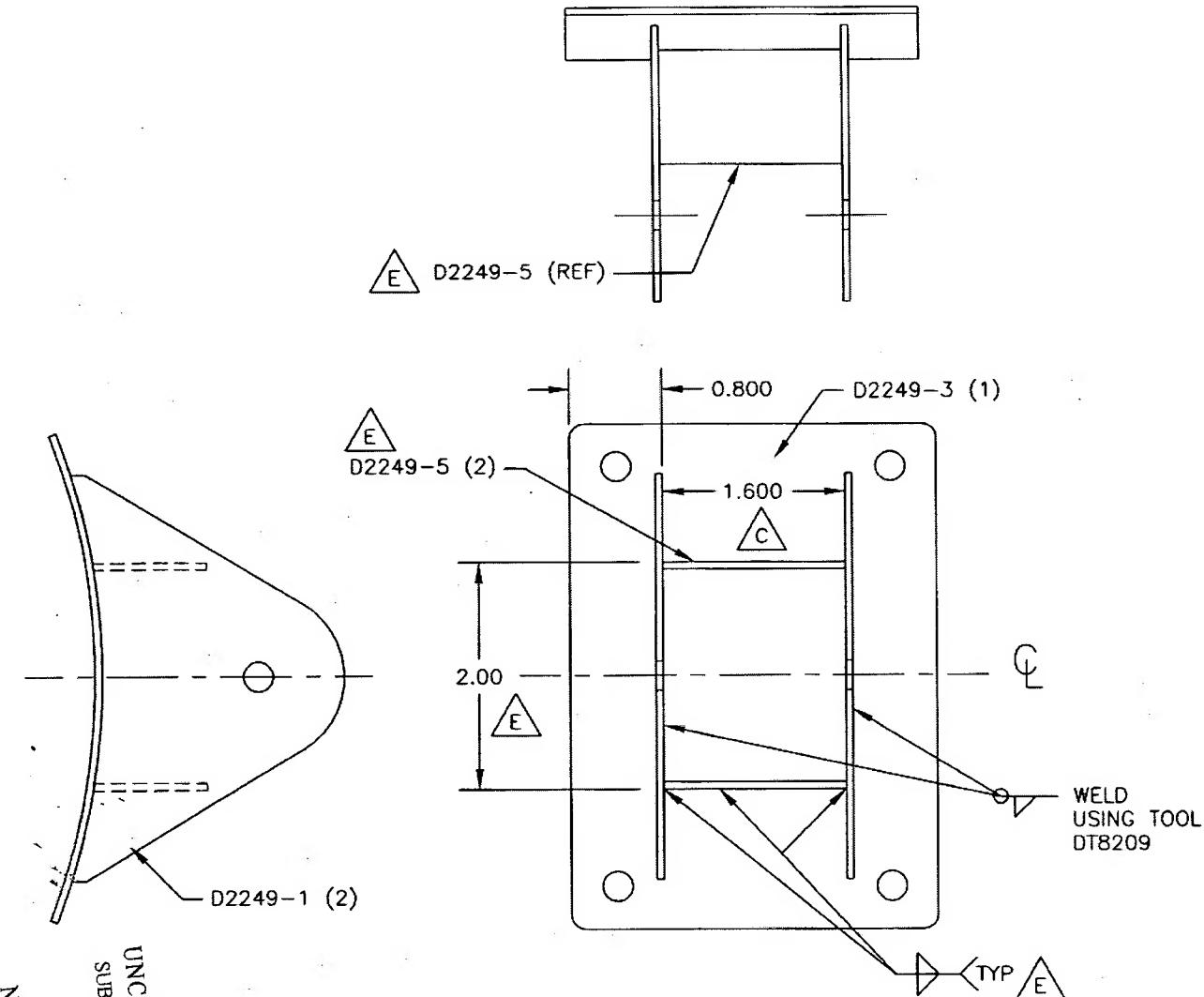
DART AEROSPACE LTD	Work Order:	34671 B
Description: Base Plate	Part Number:	D2249-3
Inspection Dwg: D2249	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BB</u>	Audited by: <u>SP</u>	Prototype Approval:	N/A
Date: <u>07-08-19</u>	Date: <u>07-08-19</u>		Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.03.23	New Issue	KJ/JLM	<i>[Signature]</i>



D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
 WELD PER DART QSI 004
 FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 ALL DIMENSIONS ARE IN INCHES
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

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 WITHOUT NOTICE
 WORK ORDER
 NO. 346215

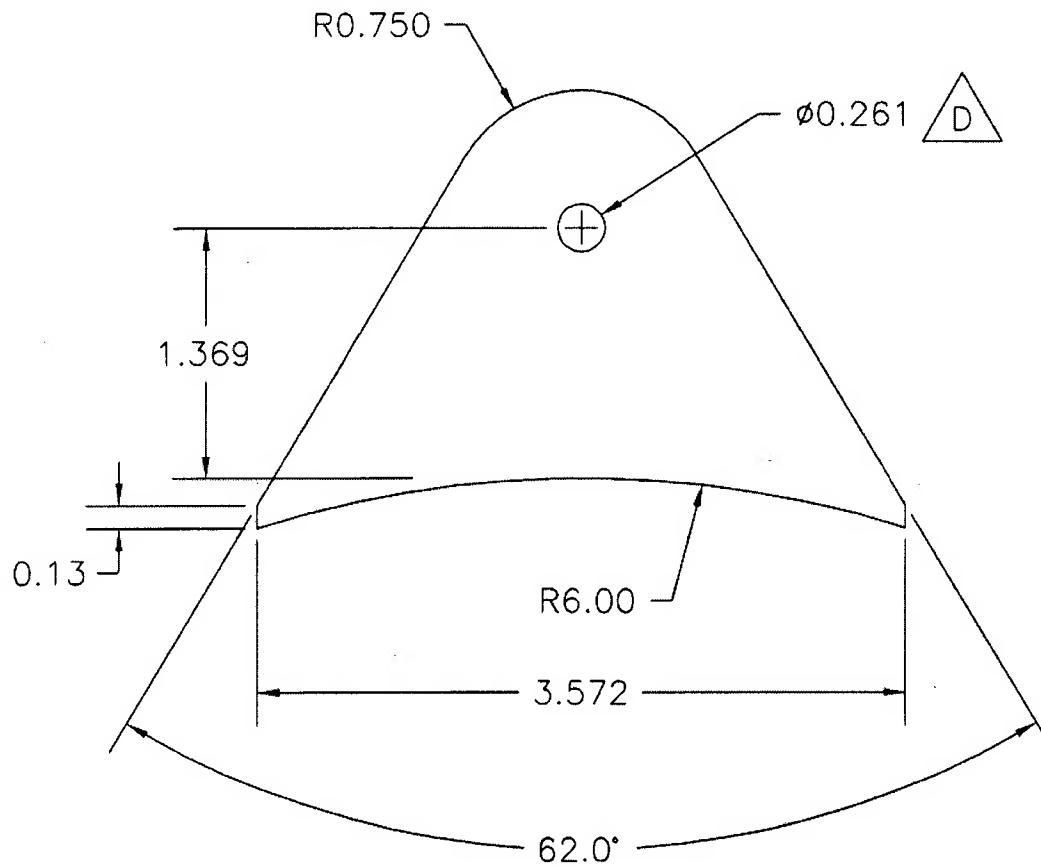
RELEASED
 94.10.12
 KE

*6 COPY
GIVEN*

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED KE	APPROVED H	DRAWING NO. D2249	SHEET 1 OF 4
DATE 99.09.20	TITLE FITTING	SCALE NTS	
A	94.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14	DIMENSION CHANGE	
D	98.04.30	ϕ 0.261 WAS ϕ 0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	

DARTCOPY ISSUED
C

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249
DATE 99.09.20	TITLE FITTING	REV. E SHEET 2 OF 4 SCALE 1:1

RELEASED
99.10.12 KED2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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34671B

DART

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CHECKED <i>KE</i>	APPROVED <i>M</i>	DRAWING NO. D2249
DATE 99.09.20	TITLE FITTING	REV. E SHEET 3 OF 4 SCALE 1:1

RELEASED
(99.10.12 KE)

Ø0.261 (TYP) D

4.44

3.690



R6.0



2.400

0.375 (TYP)

3.20

0.400 (TYP)

FLAT PATTERND2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

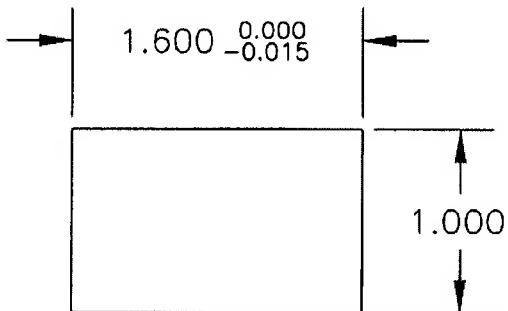
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WORK ORDER
NO. 34671B

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>SH</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED

99.10.12 KG

D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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